

Work Order ID 93880

November-27-12 10:57:26 AM

93880

Page 1

Item ID: D2739

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 350 I Beam

Start Date: 27/11/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 04/12/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: *MLS*

Date: *12-11-27* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2739	Rev E
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100

0.00

100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-5 to length as per Dwg D2739.
2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
3-Use uni-bit to open holes to finish size as per Dwg D2739.
4-Bevel Fwd end of extrusion and Deburr holes and ends.
5-Deburr

120

Chemical Conversion Coat per QS1005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

12-11-27

2 12/11/28

Work Order ID 93880

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Page 2

Item ID: D2739

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 350 I Beam

Start Date: 27/11/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 04/12/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: LG

0.00

140

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/12/03

(2)

- DC 12/12/03

12/12/5

MF 12-12-04

Picklist Print

November-27-12 10:57:29 AM

Page 1

Work Order ID: 93880

93880

Parent Item: D2739

D2739

Parent Item Name: 350 I Beam

Start Date: 27/11/2012

Required Date: 04/12/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev: C02.11.28ReformatKJ

IPP Rev: D 06-03-21 As Per Rev C JLM

IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F

10.11.02 as per revE DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-5-080

Manufactured

No

Each

156.0000

D2600-5-080

Extrusion 'I Beam' thin

**

12-11-27

Location

LG

73867

90683

Loc Qty

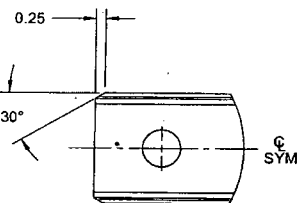
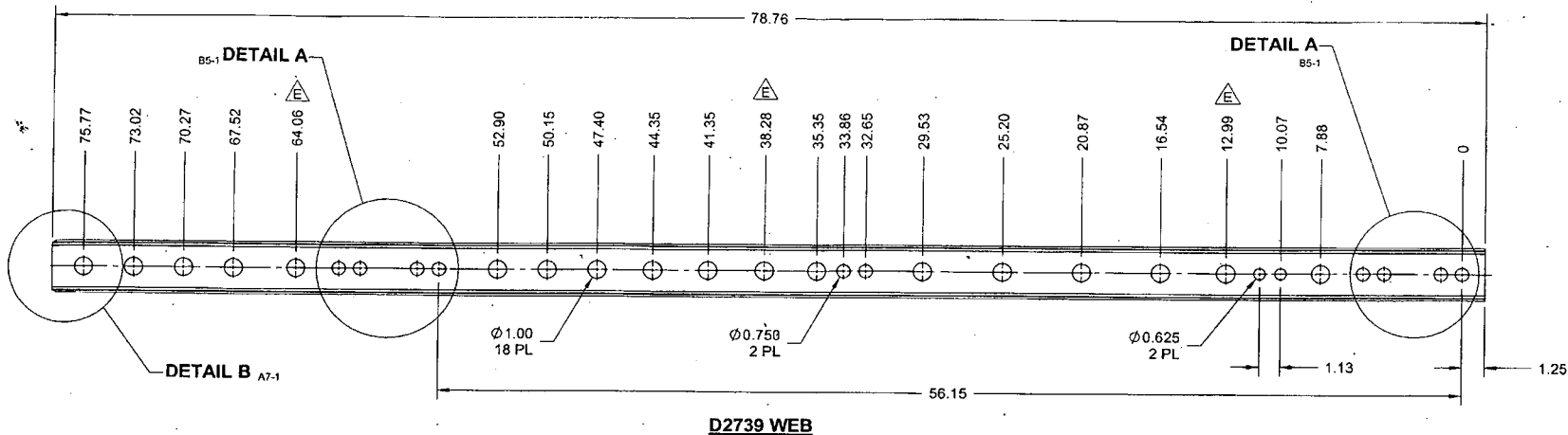
156

1

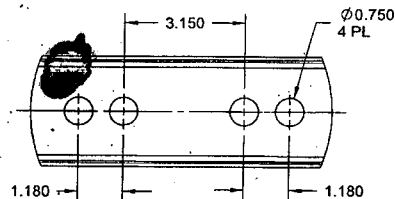
155

Loc Code

2



DETAIL B
SCALE 3X



DETAIL A
SCALE 3X

SHOP COPY
RETURN TO
ENGINEER
UNCONTROLLED COPY
SUBJECT TO CHANGE
WITHOUT NOTICE
WORK ORDER
NO 93880 ML5
12-11-27

RELEASED
2010-11-01

NOTES:

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 3.41 lbs

E	ADD/MOVE HOLES FOR D4154 WEARPLATE: 38.28 WAS 38.35 (D5-1), 64.06 WAS 64.77 (D7-1), ADD HOLE (D3-1)	CP	10.10.08
D	ADD BEVEL TO FWD END; ADD DETAIL B	CB	07.05.29
C	ADD/MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRUISER FLOATS	CP	98.11.18
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC.	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. E
MFG. APPR.	JP	D2739	SHEET 1 OF 1
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEB	NTS
DATE	10.10.08	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	